

Date: Monday, 7/30/2007 1:53:54 PM
 User: Kiri Johnston

Process Sheet

35

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 500 MIRROR ASSEMBLY
Job Number	: 33791		
Estimate Number	: 11970		
P.O. Number	:	Part Number	: D500560041
This Issue	: 7/30/2007 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: N/A
Previous Run	: 33193	Material	:
Written By	:	Due Date	: 8/30/2007 Qty: 10 Um: Each
Checked & Approved By	: <u>07.07.30</u>		
Comment	: Est Rev: 03.10.15 Reformat; Removed D2057 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D500-560-041 CHG004

07.07.31
 2 Aug 07

2.0	D1048	Clamp
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D1048	Clamp	B29769

mf

3.0	D1049	Saddle
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D1049	Saddle	B29770

mf

4.0	D2010101	Mirror Bracket 369/500
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2010-101	Bracket	B33914

x 8mx, B24060 x 2mx.

mf
 07-11-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 500 MIRROR ASSEMBLY

Job Number: 33791

Part Number: D500560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2010103

Mirror Arm 369/500



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2010-103 Bracket B 35204 x 2m, B 33915 x 8mx

mf

6.0

D2011101

Mirror 6"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2011-101 Mirror B 33916

mf

7.0

AN526C1032R10

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN526C1032R10 Screw m15072

mf

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per drawing D500-560

mf 07-11-06

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/11/06 (10) contop

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

11.0

AN34A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

M103287 25X M103641 15X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:53:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 500 MIRROR ASSEMBLY

Job Number: 33791

Part Number: D500560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN3-4A Bolt

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 07/11/07

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D500-560-041

Location: _____

PPP Rev: _____

D

AS 07/11/07

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.11.07

Job Completion



U 07.11.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

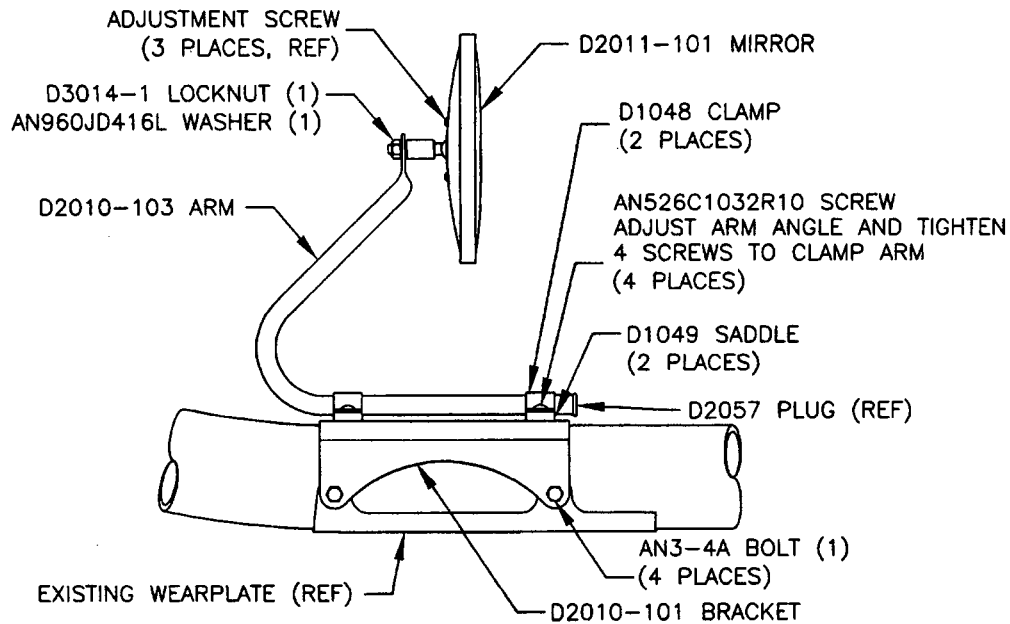


Figure 2: Installation of D500-560-041 Cargo Mirror Assembly

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D500-560-041	1.0 lb	-45 in	-45 lb-kG	24 in	24 in-lb
Cargo Mirror Assembly	0.45 kg	-1.14 m	-0.51 m-kG	0.61 m	0.27 m-kG

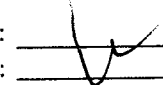
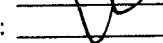
5. PARTS LIST

Qty	Part Number	Description
X	D500-560-041	CARGO MIRROR ASSEMBLY
1	D2011-101	MIRROR
1	*D3014-1	LOCKNUT
1	*AN960JD416L	WASHER
2	D1048	CLAMP
2	D1049	SADDLE
1	D2010-101	BRACKET
1	D2010-103	ARM
4	AN3-4A	BOLT
4	AN526C1032R10	SCREW (OR AN526-1032R10)

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

Date: Friday, 20/06/2008 10:40:33 AM
 User: Linda Lacelle

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	D500-560-041
Job Number :	39980	Part Number :	ECN20
Estimate Number :	10804	Drawing Number :	ECN1195P/1204
P.O. Number :		Project Number :	
This Issue :	20/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	
First Issue :	20/06/2008	Material :	
Previous Run :	39979	Due Date :	27/06/2008
Written By :		Qty:	6 Um: Each
Checked & Approved By :			
Comment :			

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

1 X D500-560-041 B30357

5 x D500-560-041 B33791

see attached

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

REMOVE FROM KITS ALL D2010-103

SCRAP PARTS PER ECN1195P/1204

REASSEMBLE USING NEW D2010-103,

ANY BATCH OVER 39208+

*SB 08/06/23**SB 08/06/23*

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 08/06/23 (+6)

4.0

D2010103

Mirror Arm, 500



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Mirror Arm 369/500

B 39504

*see attached**u*